

Date: Tuesday, 3/11/2008 7:57:46 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 37755	
Estimate Number : 10312	
P.O. Number :	Part Number : D2646
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 36184	Material :
Written By :	Due Date : 3/17/2008 Qty: 50 Um: Each
Checked & Approved By : <u>080311</u>	
Comment : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM	
Est Rev:H Changed Inserts 07-02-19 JLM	
est rev I changed inserts 07.06.11 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 5891
1-Spin as per Dwg D2646
2-Material release note required

08/03/12 (50)

2.0	D2646P	Aft Cap
-----	--------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage
Ensure Material Release Note is attached

08/3/08 (50)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

08/03/25 (x50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

2-Open holes to .297. as per Dwg D2646.

FF 08-03-31

(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 37755

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/31 (KSD)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

08-03-31

(50)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 08/04/01

(50X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/04/01

(50)

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

INSERT

Batch:

M 105854

FZ

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

FZ 08/04/01

(50)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/01 (KSD)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

F-P 22

M-L 08/04/01

(50X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 7:57:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 37755

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03

[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



6 08.04.02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

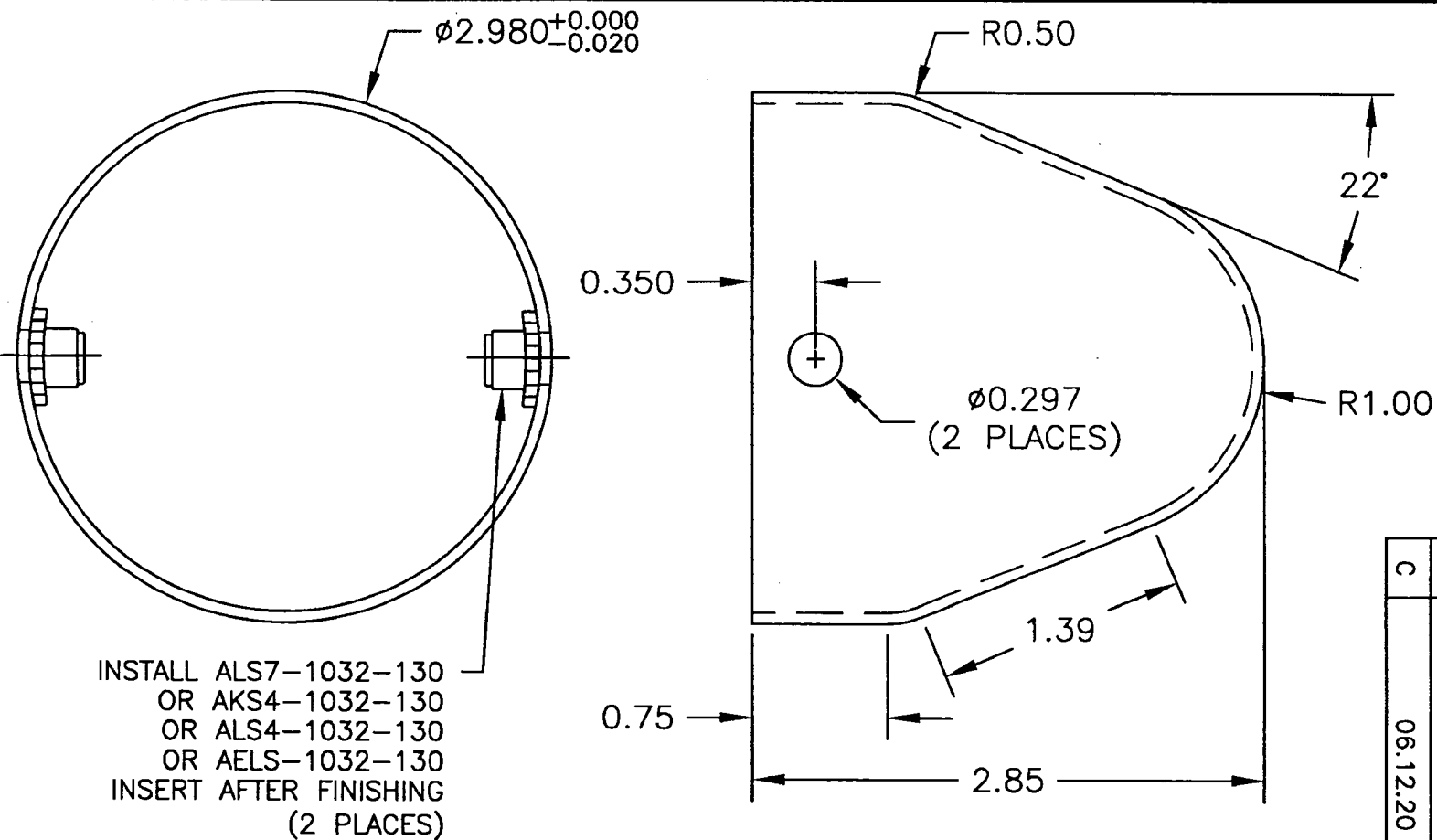
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DS	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. C
CHECKED		APPROVED		DRAWING NO. D2646	SHEET 1 OF 1
DATE	06.12.20			TITLE AFT CAP	SCALE 1:1
A		97.03.25		NEW ISSUE	
B		05.04.01		CHANGE TO CLOSED INSERTS	
C		06.12.20		CHANGE TO OPEN ENDED INSERTS	



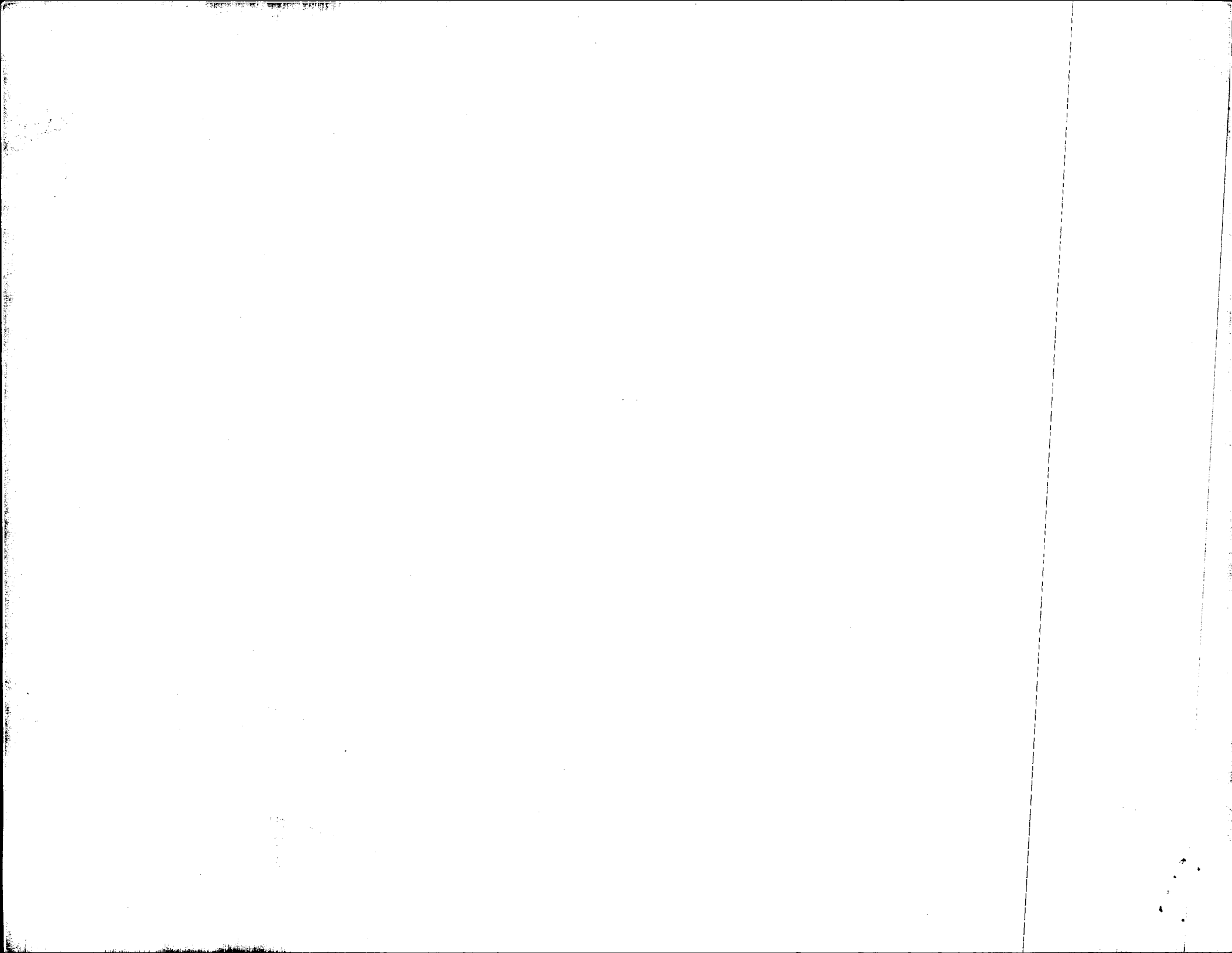
D2646 AFT CAP

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37755

RELEASED

07.02.20





Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: March 24/08
Customer: Dart Aerospace
Packing Slip: 35085

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2646P	50	14G1100	N/A	✓	<i>[Signature]</i>

Notes:

Material Certification Attached: Yes.

Wm. GERRY



ALCOA MILLS PRODUCTS
1480 Manheim Pike
Lancaster Pa 17601

Certification of Test Results

P/N 970200

PO 38C880

SOLD TO	SHIP TO	CERT NO	0000675996
		DATE	4/23/2007
		SKID NO	661033
		SKID WGT	9.885
		PAGE	1 OF 1

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED
ITEM NO	1	PART NO				
ALLOY	1100	TEMPER	0	FORM	COIL	
GAUGE	0.0300	WIDTH	48.0000	LENGTH	0.0000	

LOT: 334171 COIL: B01 DROP: 07T0187

INGOT	SI	FE	CU	MN	MG	CR	NI	ZN	TI
U718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 13.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 C, AMS 4001H 1100 C,
ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O

PAX CERTS: 714-736-4840

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

These methods, technology and software reported from the United States is unclassified with the Export Administration Regulations. Diversion contrary to U.S. law prohibited.

Authorized By:

JEFF KREADY, LAB SUPERVISOR

Order No.: 376276

Part:

PO: 38C880

Sold to: COPPER & BRASS SALES

TR clerk signature: *C. Perry*